



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-312
Job Sheet 200621



Part No: D206-642-312

Job Qty: 1 pcs

Part Name: Skidtube RH, Low & High Gear with Standard Wearplates



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV Q SHEETS 29-30 IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC PP Rev:O as per REV.N DD 10.04.19 verified by:EC IPP Rev:P 12.11.21 ECN12-679 DD verf:JLM IPP Rev:Q 14.04.25 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	10/18/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23	PC	OCT 16 2019
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		



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Container No: S227873



Part: D206-642-312

Job No: 200621

Serial No/Batch: S227873

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17 FAA STC SH98-

120 QC 4	1 pcs	10/18/19	0.00 0.00	Packaging 1 - 29	
				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
130 Packaging 3-1 - Stock - B4B 1 pcs		10/18/19	0.00 0.00	Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
135 DC - 1 - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				DC - 1 - B4B	
				DC - 2 - B4B	
				QC 21 - FG - 21	
				QC 21 - FG - 70	
140 QC 21 - FG	1 pcs	10/18/19	0.00 0.00		

DAS
78 NOV 07 2019
9-89

DAS
78 NOV 07 2019
9-89

DAS
21 NOV 07 2019

DAS
21 NOV 07 2019

Part Op 110 - Pick Kit
Descriptions: 120 - QC4- 100% inspect kits for completeness

PKG

130 - Identify and pack for shipping as per PPP D206-642-312

135 - Document Control - Photocopy bluefile and create labels per PPP D206-642-312 CHG008

140 - QC21- Final Inspection - Work Order Release

012433

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5214966
AN4-6A	Bolt	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5211539
AN4C5A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5207679
AN5-10A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5200190x2 5205280x2
AN5-11A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5167553
AN5-12A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5003926
D206-642-341	Replacement Stud Tube (Fits LH or RH)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5217055
D206-648-013	Ground Handling Wheel Modification	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5225638
D2652	Bushing	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	5169405
D2712	Set Screw	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	5220711
D2932-2	Saddle RH Out. 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218114
D2933-2	Saddle RH In. 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5214496
D2934	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219250
D2935	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220045
D2938-2	Saddle RH Out. 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218950
D2939-2	Saddle RH In. 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5204277
D3407-043	Tow Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5207076
D3413-1	O-Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128864
D3456-1	Washer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5216481
D3457-1	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5211533
MS21042L3	Nut	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5214467
MS21042L4	Nut	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5203359
MS21043-4	Nut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5194667
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5201031
NAS1149D0363J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5216019
NAS1149D0463J	Washer	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5174288
NAS1149D0563J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-41A	8	53	0
	AN4-6A	12	308	0
	AN4C5A	1	70	0
	AN5-10A	4	138	0
	AN5-11A	8	73	0
	AN5-12A	4	238	0
	D206-642-341	1	2	0
	D206-648-013	1	4	0
	D2652	16	218	0
	D2712	10	319	0
	D2932-2	1	6	0
	D2933-2	1	4	0
	D2934	2	7	0
	D2935	2	24	0
	D2938-2	1	5	0
	D2939-2	1	0	0
	D3407-043	1	9	0
	D3413-1	1	19	0
	D3456-1	1	157	0
	D3457-1	2	10	0
	MS21042L3	8	1,950	0
	MS21042L4	12	1,314	0
	MS21043-4	1	502	0
	NAS1149C0463R	1	214	0
	NAS1149D0363J	8	788	0
	NAS1149D0463J	24	2,529	0
	NAS1149D0563J	8	1,376	0

Part Specifications

Specifications could not be found.

Plex 9/13/19 8:33 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details:

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-642-043	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-44A	BOLT
11	16	16	16	16						D2952	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-44A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3428-1)
22A					1	1				D4958-11	WEARSHOE (REPLACES D3535-11 + D3538-11)
23A					1	1				D4958-23	WEARSHOE (REPLACES D3535-23 + D3538-23)
24A					1	1				D4958-35	WEARSHOE (REPLACES D3535-35 + D3538-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D2407-043	TOW RING ASSEMBLY (REPLACES D2868-043)
32A	1	1	1	1						D2458-1	WASHER
32B	2	2	2	2						D2457-1	WASHER
33	1	1	1	1						MS21043-1	NUT
34	1	1	1	1						AN4C6A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						B3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2713	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2852	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q
Date: 13.08.12

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-38A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4381-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: Q

Date: 13.08.12

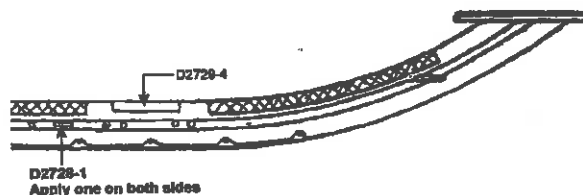
RELEASED
15.10.19

PPP

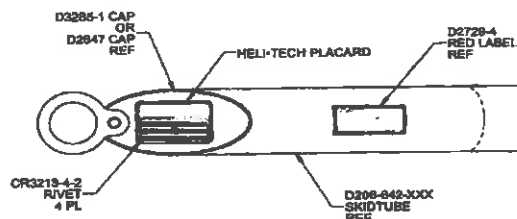
Part Number	D206-642-312	Box Part Number	MBX105	Dimension	L x W x H 123" x 7" x 7"
Description	Skidtube, RH	Other Packaging	MF166	Dimension	MF668
		Logo Decals	D2728-1		

Packaging Instructions and Decal Placement**D206-642-312**

Apply label D2729-4 and D2728-1 as per drawing.
Wrap skidtube in plastic. Place (2) pieces of MF166 at each ends of the box and glue to interior. Place (3) pieces of MF668 in bottom of box. Place skidtube in box. Put kit in foam, apply label D2729-3 on top and place in box. Put (3) pieces of MF668 on top to correspond with bottom foam already in place. Close box.
Apply Dart tape. Apply strapping after first Dart logo, thereafter applying strapping after every second Dart logo.
Apply clear tape over strapping. Apply label D2729-3 as per instructions in QSI 014.



For skidtubes that are manufactured as a PMA replacement part, a Heli-Tech placard and the D2729-4 label must be installed on the skidtube as per drawing below.



D2729-4

D2729-3

DART			
US #5735484 / CA #2222184 / EURO #0828655			
P/N: D206-642-312		Q/N: CHG008	
D/C: Skidtube, RH		Q/T: SH98-4	
B/N: BXXXXXX		S/N: SA00475SE	
Bell 206L/L1/L3/L4/407			

DART AEROSPACE		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200
SKIDTUBE, RH		
P/N: D206-642-312		CHG008
B/N: BXXXXXX		

Revision: J
Date: 15.10.19

S
45/10/19